



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60849**

Monday, July 26, 2010 10:41:41 AM

Page 2

Item ID: D2281

Accept

Setup Start

Revision ID:

Stop

Item Name: Jack Saddle

Start Date: 7/26/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

Debur

u/25

140

0.00



NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form as per D2281 using D2281-T2

8/16/08/05

RUR

150

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

8/16/08/05

X50

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**NOTE:** Date & initial all entries

**Work Order ID 60849**

Monday, July 26, 2010 10:41:42 AM



Page 3

Item ID: D2281

Accept



Setup Start



Revision ID:

Stop



Item Name: Jack Saddle

Start Date: 7/26/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: *w/o*

0.00



Packaging

Memo

*60285*

0.00

Packaging

*EL 10-8-23**(X58)*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/08/23**C2 10/8/23*

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 26, 2010 10:41:45 AM

Page 1

Work Order ID: 60849



Parent Item: D2281

Parent Item Name: Jack Saddle



Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM  
IPP: rev B 06.07.17 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA  304SS sheet .080		Purchased	No			100	sf	113.0608	0.125	5.263158	6.25		
											1310-7-28		

Location

MAT20

113295

Loc Qty

113.0608

113.0608

Loc Code

113295

(50)

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	60849
<b>Description:</b> Jack Saddle		<b>Part Number:</b>	D2281
<b>Inspection Dwg:</b> D2281 <b>Rev:</b> G		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.472	*		V Rod	
4.114	+/-0.010	4.112	*		V	
2.933	+/-0.010	2.937	*		V	
1.535	+/-0.010	1.539	*		V	
0.354	+/-0.010	.354	*		V	
0.354	+/-0.010	.354	*		V	
0.604	+/-0.010	.604	*		V	
2.000	+/-0.010	2.001	*		V	
3.396	+/-0.010	3.396	*		V	
3.646	+/-0.010	3.646	*		V	
4.000	+/-0.010	4.005	*		V	
1.525	+/-0.010	1.521	*		V	
2.475	+/-0.010	2.479	*		V	
Ø0.323	+0.006/-0.001	.326	*		V	
0.080	+/-0.010				V	

<b>Measured by:</b>	IB
<b>Date:</b>	10-7-08

<b>Audited by:</b>	S
<b>Date:</b>	10/08/04

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

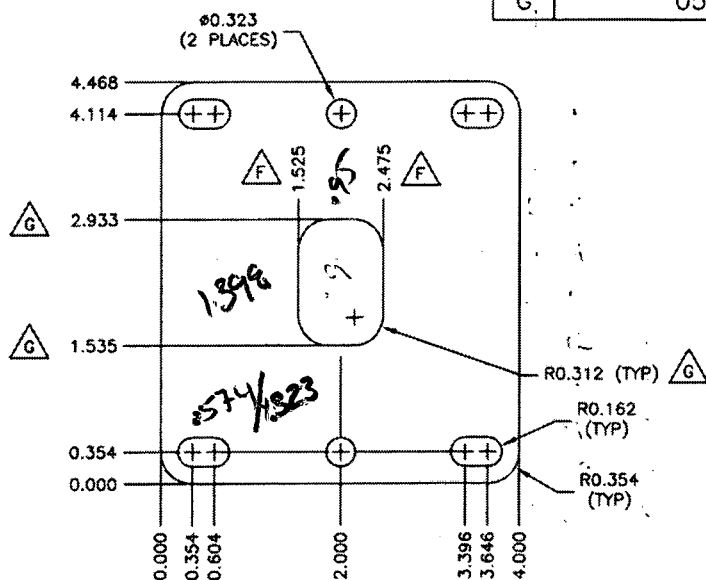
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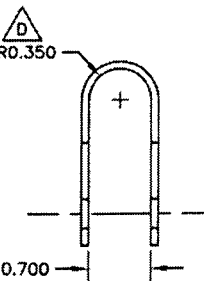
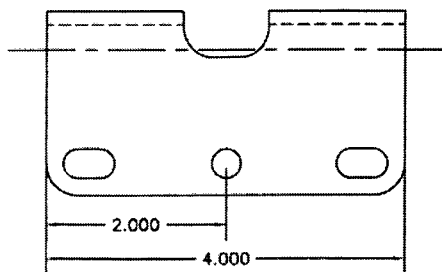


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED  
*[Signature]*  
05/08/11



FLAT LAYOUT



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 608449

*pl10-727*

**D2281 JACK SADDLE**

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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